

# Work Order ID 112221

January-30-14 11:18:40 AM

647.9411

\*112221\*

Page 1

Item ID: 647.9411

B112932

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Upper Deflector

Start Date: 1/30/14 Start Qty: 8.00 \*8\*

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 8.00 \*8\*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 14-01-31

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Rejec Num er	Insp. Stamp
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Draw Nbr	Revision Nbr
647.9400	A2 <u>B. A.</u>

100

\*100\*

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 32.625"

\*\*\* ONE BLANK MAKES TWO PARTS\*\*\*

0.00

0.00

14/04/09

8

DAS

14

9-89

110

\*110\*

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB196

DWG REV: A

FOLIO REV: AA

2- deburr and break all sharp edges

0.00

0.00

B. A 14/04/11

8

DAS

08

9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 112221**

January-30-14 11:18:40 AM

**\*112221\***

Page 2

Item ID: 647.9411

Revision ID:

Item Name: Upper Deflector

Start Date: 1/30/14

Start Qty: 8.00

**\*8\***

Required Date: 1/30/14

Req'd Qty: 8.00

**\*8\***

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

B.O 14/04/11

8

0

DAS  
08  
9-89

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

DAS  
44  
9-89

14/04/12

8

0

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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**Work Order ID 112221**

January-30-14 11:18:40 AM

**\*112221\***

Page 3

Item ID: 647.9411

Revision ID:

Item Name: Upper Deflector

Start Date: 1/30/14 Start Qty: 8.00 \*8\*

Required Date: 1/30/14 Req'd Qty: 8.00 \*8\*

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

**\*140\***

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O to ATG : 238/3

1- Black Anodize as per Dwg 647.9400

2- PRIME AS PER DWG, SEE NOTE #7 (\*\*DISREGARD AFTER  
ASSEMBLY\*\*)

Certification of Conformity is required

150

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

CZ 14/04/15 8Pay/20 (8)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 112221**

January-30-14 11:18:40 AM

**\*112221\***

Page 4

Item ID: 647.9411

Revision ID:

Item Name: Upper Deflector

Start Date: 1/30/14

Start Qty: 8.00

**\*8\***

Required Date: 1/30/14

Req'd Qty: 8.00

**\*8\***

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

155

QC5- Inspect part completeness to step on W/O

0.00

DAS

16

9-89

14/05/08

**\*155\***

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: ~~MT~~

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

\*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV\*\*\*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

MLJ 14-05-09

14-05-08

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

January-30-14 11:18:40 AM

Page 1

Work Order ID: 112221

Parent Item: 647.9411

Parent Item Name: Upper Deflector

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV: A NEW ISSUE JFS 13/06/19 VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B5.000X0.375 7075-T6 BAR 5.000" X 0.375"		Purchased	No			100	f	9.5000	1.36	12			

Location

Loc Qty

Loc Code

MAT049

9.5

m126615

8

m127614

1.5

M128502 X 12

14/04/09

DAS  
14  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
--	--	---	--



APICAL  
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04230

SHEET 1 OF 2

DWG NO. 647.9400

REV: A

PREPARED BY J. SOTO

DATE: 11/11/2013

EFFECT ON DWG  
☐ INC. ☒ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY:

ENGR

MFG

QC

EFF.

NEXT ORDER

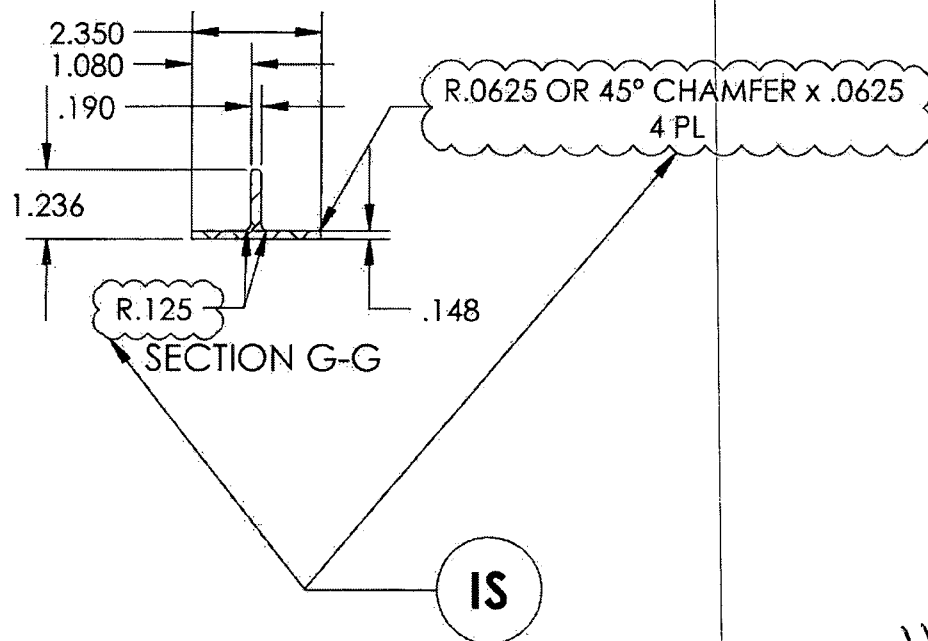
TRANSACTION CODES (TC):  
A-ADD  
R-REVISE  
C-CREATE  
D-DELETE

REASON: REVISED DIMENSIONS AND ADDED OPTION FOR CHAMFER. REVISED TOLERANCES

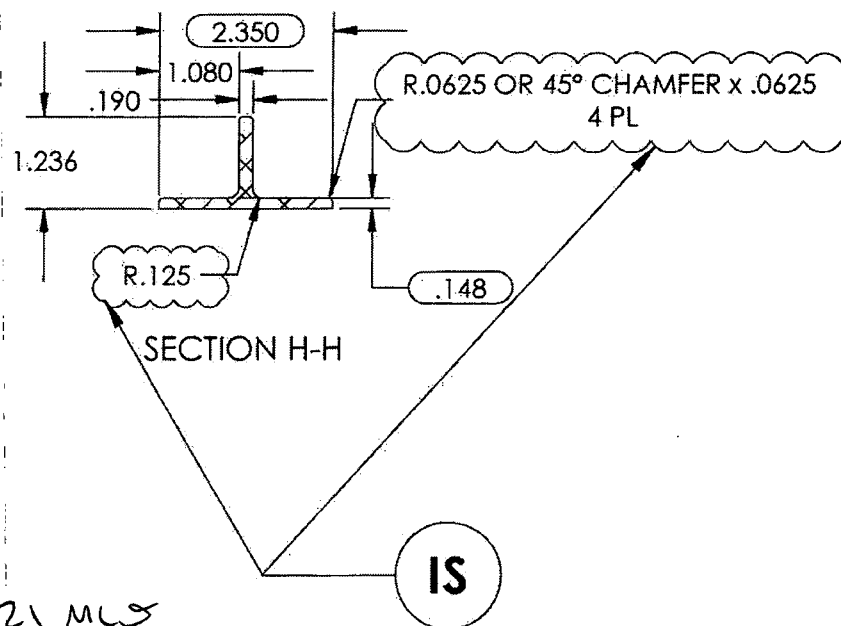
ECR:

13-031

**SHEET 6, ZONE A4 IS:**



**SHEET 7, ZONE D4 IS:**



112221 MLC  
14-01-31

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

**SHEET 2 AND 5-9, ZONE D7 IS:**

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE:  
2 PLACE DECIMALS  $\pm .03$   
3 PLACE DECIMALS  $\pm .010$   
ANGLES  $\pm .5^{\circ}$

IS



**APICAL**  
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04389

SHEET 1 OF 1

DWG NO. 647.9400

REV: A

PREPARED BY J. SOTO

DATE: 01/28/2014

EFFECT ON DWG  
☒ INC. ☐ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]*

QC *[Signature]*

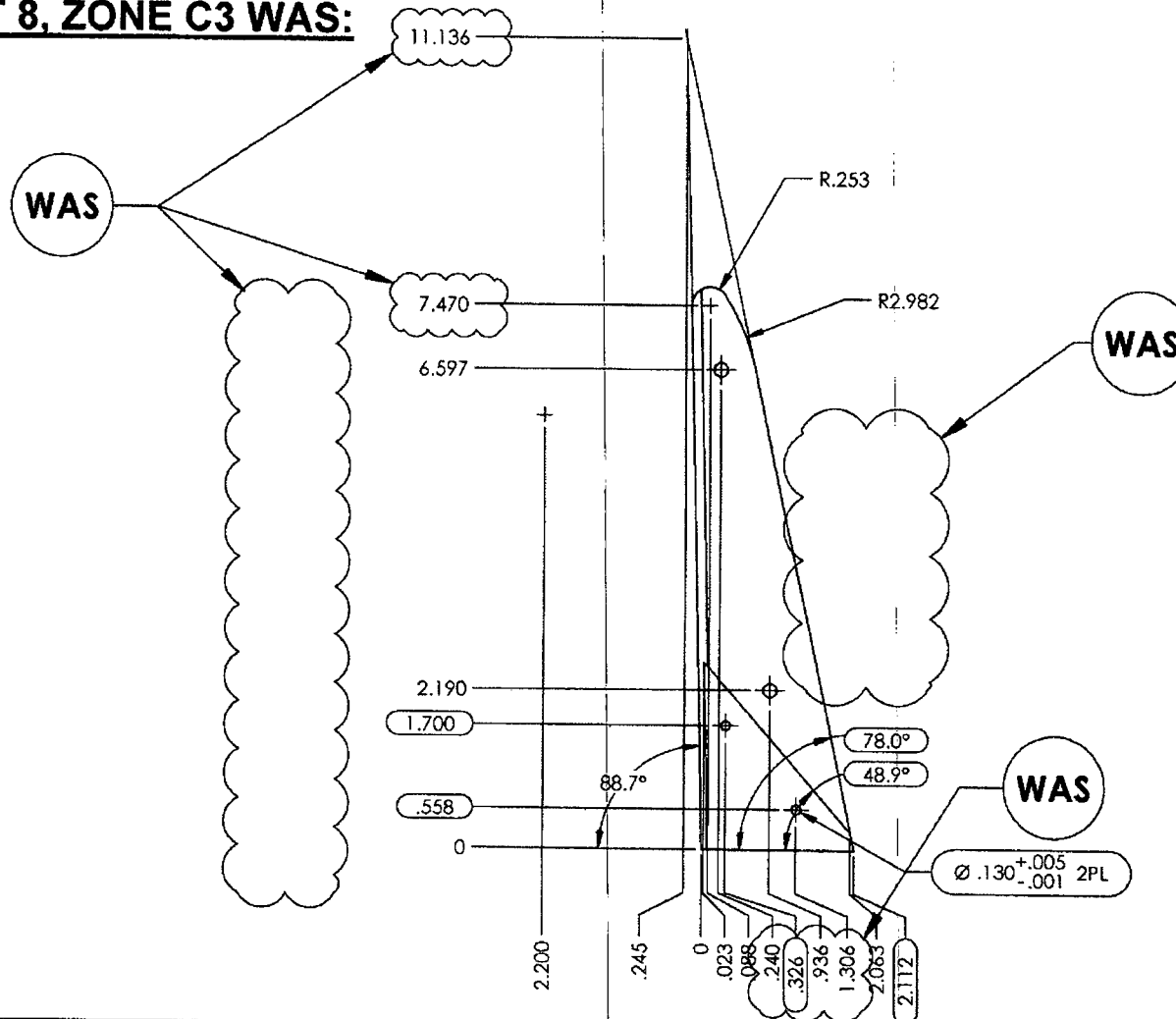
EFF. NEXT ORDER

TRANSACTION CODES (TC):  
A-ADD  
R-REVISE  
C-CREATE  
D-DELETE

REASON: REVISED, ADDED, & DELETED INSPECTION DIMENSIONS TO 647.9414.

ECR: D-14-01

**SHEET 8, ZONE C3 WAS:**



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

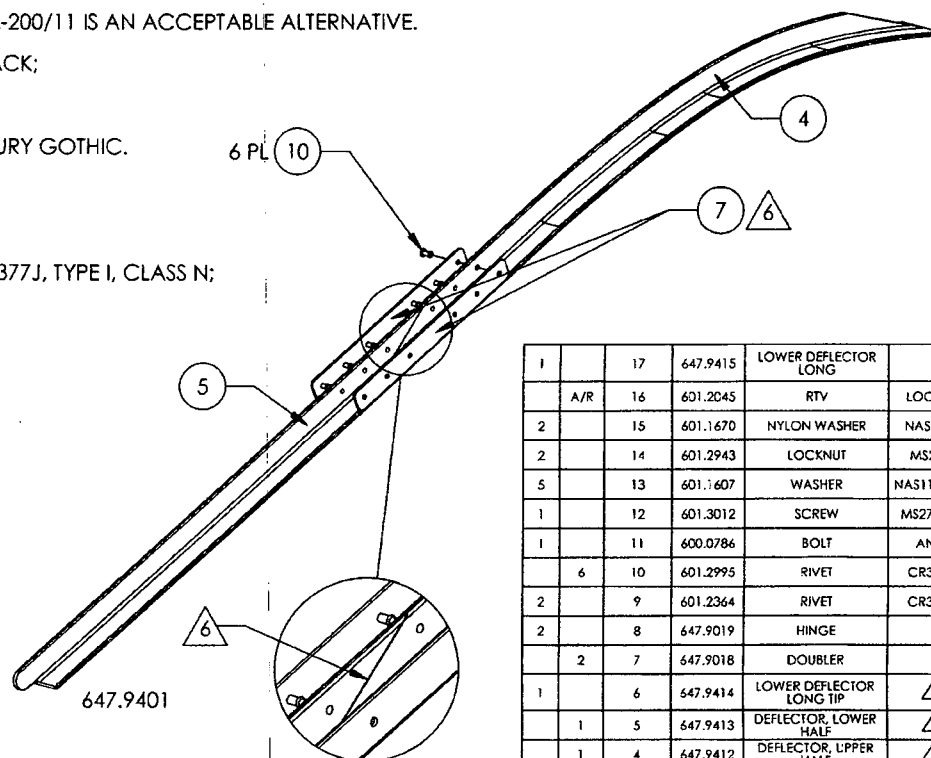
DER REVIEW REQUIRED

☐ YES ☒ NO

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# NOTES: UNLESS OTHERWISE SPECIFIED

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12. AMS-QQ-A-200/11 IS AN ACCEPTABLE ALTERNATIVE.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DE BURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION, 12 PT. CENTURY GOTHIC.
5. ALL DIMENSIONS SHOWN PRIOR TO FINISH.
- 6 APPLY F/N 17 TO FAYING SURFACES.
- 7 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
- 8 TORQUE 15-20 IN.-LBS.
- 9 DIMENSION SHOWN IS FOR INSPECTION AFTER FINISHING.



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PRODUCTION RELEASE: P/N 1		
2	INITIAL RELEASE	04-09-10	P. BRAYO
3	INCORPORATE ECH 0207, 0208, 0210 & 0214	10-23-12	J. CLARK
4	INCORPORATE ECH 0211, 0212, 0420 & 0430	01-28-14	P. BRAYO

1	17	647.9415	LOWER DEFLECTOR LONG		
	A/R	16	601.2045	RTV	LOCTITE 598
2	15	601.1670	NYLON WASHER	NAS151SH3L	
2	14	601.2943	LOCKNUT	MS21042-3	
5	13	601.1607	WASHER	NAS1149F0332P	
1	12	601.3012	SCREW	MS27039-1-15	
1	11	600.0786	BOLT	AN3C7A	
6	10	601.2995	RIVET	CR3213-6-6	
2	9	601.2364	RIVET	CR3213-4-8	
2	8	647.9019	HINGE		
2	7	647.9018	DOUBLER		
1	6	647.9414	LOWER DEFLECTOR LONG TIP	△	△△
1	5	647.9413	DEFLECTOR, LOWER HALF	△	△
1	4	647.9412	DEFLECTOR, UPPER HALF	△	△
1	3	647.9501	QUICK RELEASE PIN ASSY		
	2	647.9411	UPPER DEFLECTOR	△	△△
	1	647.9410	LOWER DEFLECTOR	△	△△
		647.9402	LOWER DEFLECTOR LONG ASSY		
		647.9401	DEFLECTOR ASSY		△
9402	9401	FIND #	PART #	DESCRIPTION	MATL SPEC.

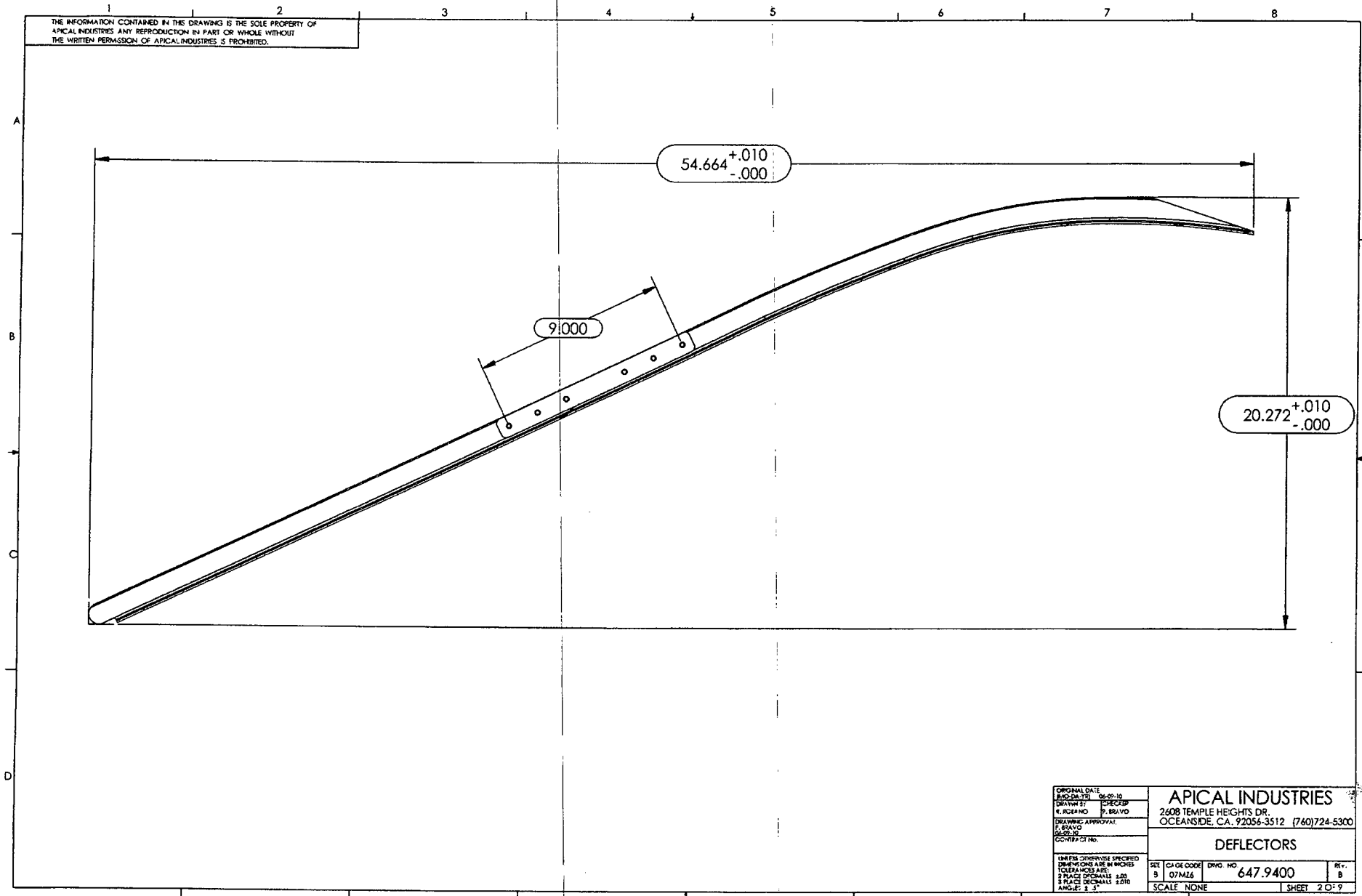
QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE 04-09-10	
647.8900		DRAWN BY CHECKED	
647.9200		P. BRAYO	
		DRAWING APPROVAL	
		04-09-10	
		CONTRACT NO.	
		UNLESS OTHERWISE SPECIFIED	
		DIMENSIONS ARE IN INCHES	
		TOLERANCES ARE:	
		2 PLACE DECIMALS ±.003	
		3 PLACE DECIMALS ±.001	
		ANGLES ±.5°	
		SCALE NONE	
		SHEET 1 OF 9	

APICAL INDUSTRIES  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760)724-5300

## DEFLECTORS

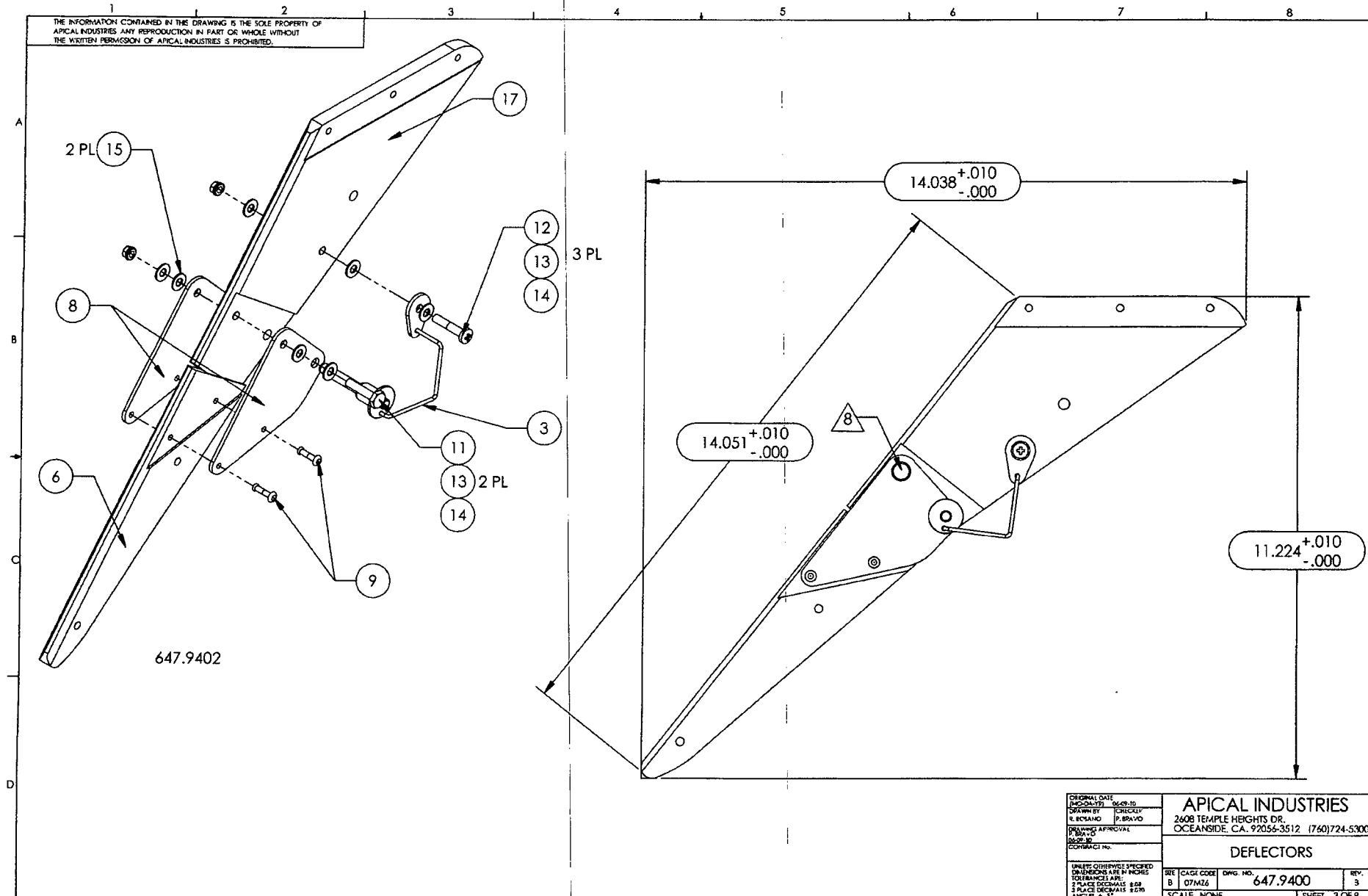
REV. 8  
CAGE CODE 07M26  
DWG. NO. 647.9400  
SCALE NONE  
SHEET 1 OF 9

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THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

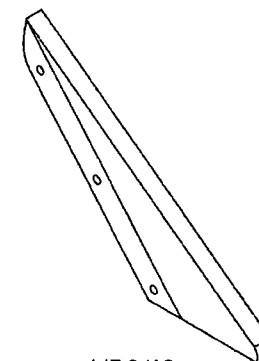


ORIGINAL DATE  
(ISO-DAY-YR) 06-29-10  
DRAWN BY  
N. REYANO P. BRAYO  
DRAWING APPROVAL  
P. BRAYO  
CONTRACT NO.

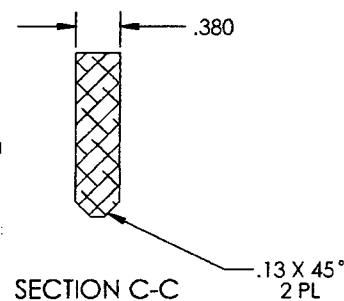
**APICAL INDUSTRIES**  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760)724-5300

**DEFLECTORS**

SHEET	CAGE CODE	DWG. NO.	REV.
B	07M26	647.9400	3
SCALE NONE			SHEET 3 OF 9

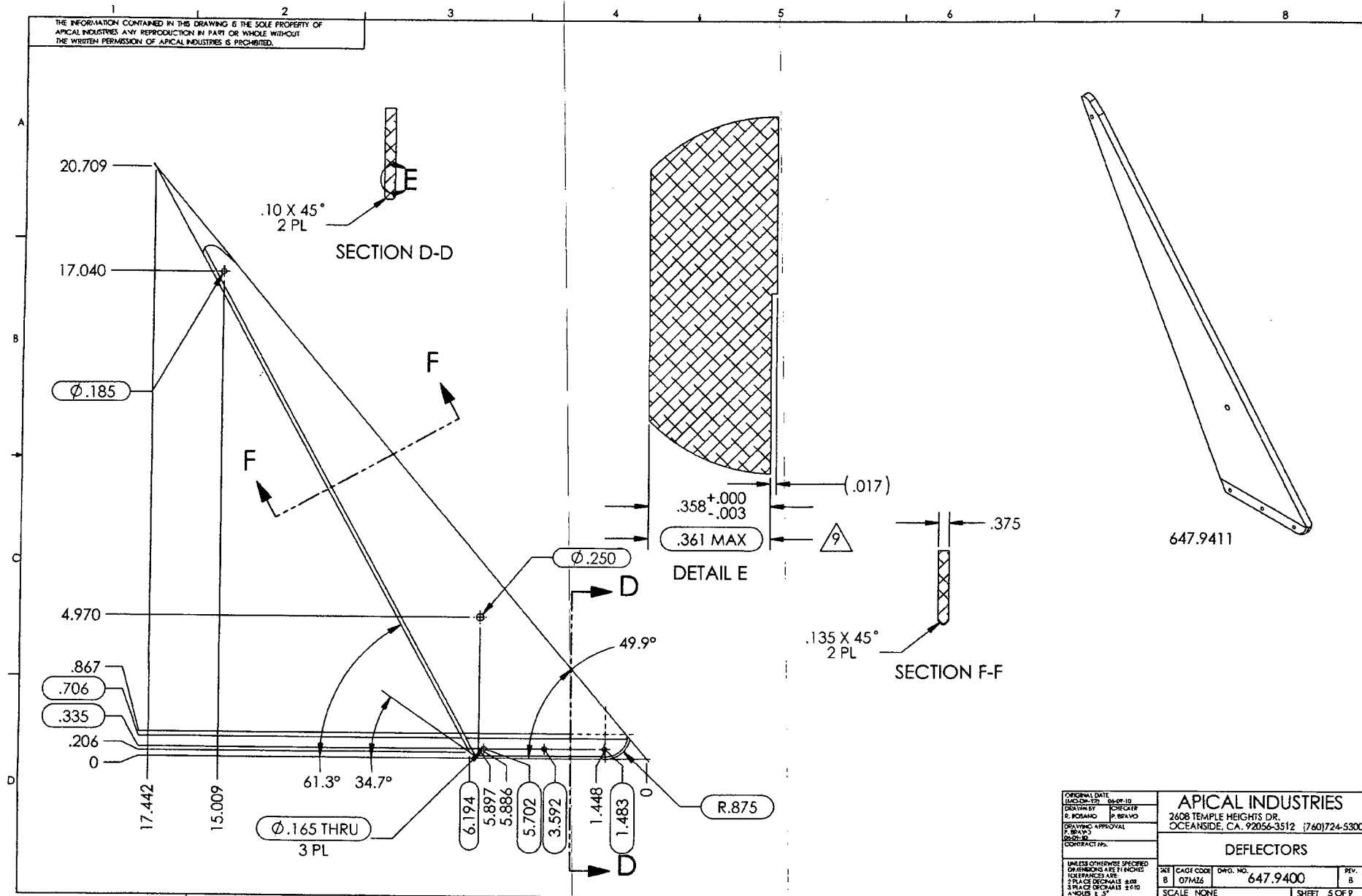
[illegible]

647.9410



ORIGINAL DATE (MCO-DM-172) 04-09-10 DRAWING NO. CHECKED 672-140 17-BRAVO DRAWING APPROVAL 17-BRAVO CONTRACTOR NO.	<div style="text-align: center;"> <h1>APICAL INDUSTRIES</h1> <p>2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)774-5300</p> </div>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES 10 POUNDS RANGE 1-5 1 POUND DIMENSIONS 1-50 1 POUND DIMENSIONS 1-50	<div style="text-align: center;"> <h2>DEFLECTORS</h2> </div>
SEE B CAGE CODE 07M26	<div style="text-align: center;"> <h2>647.9400</h2> </div>
SCALE NONE	<div style="text-align: right;">         REV B          SHEET 4 OF 7       </div>

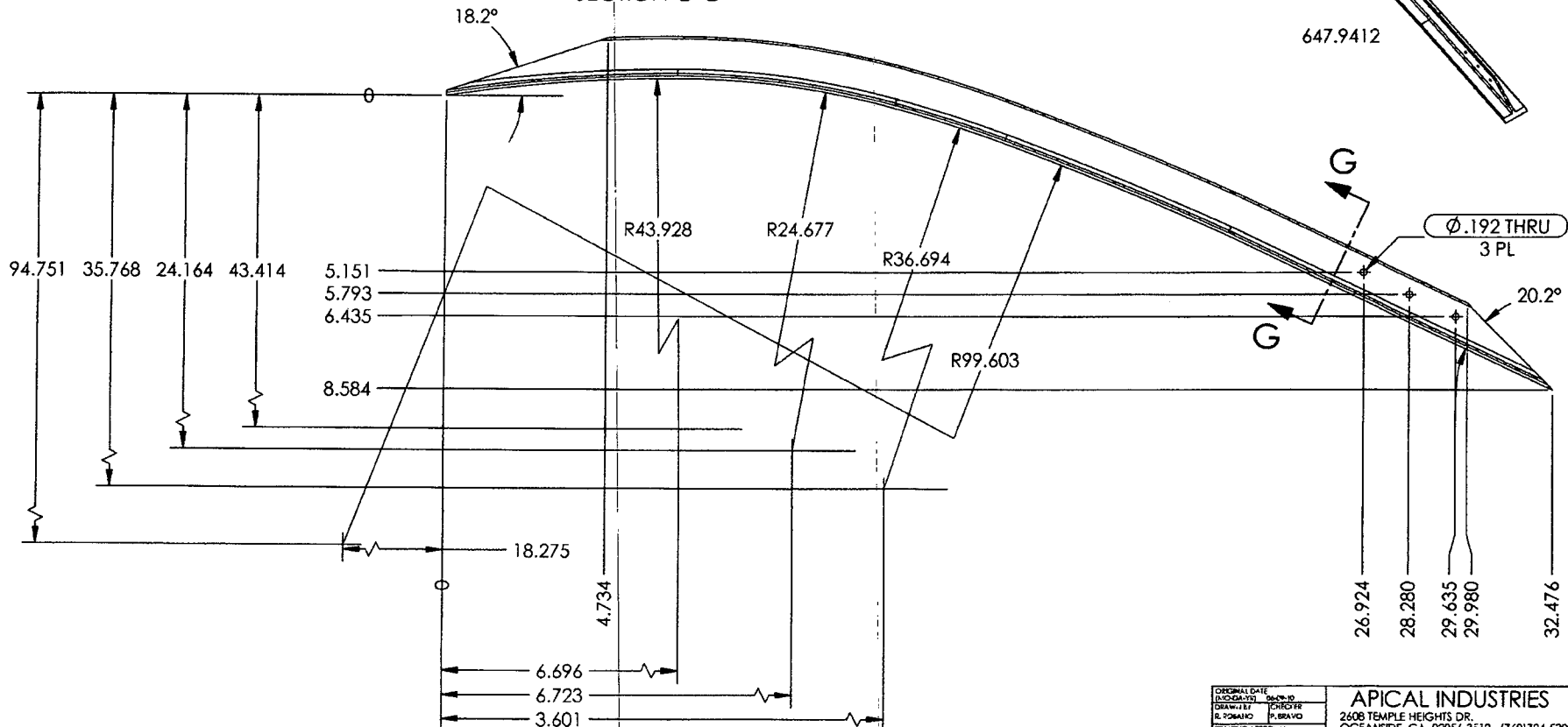
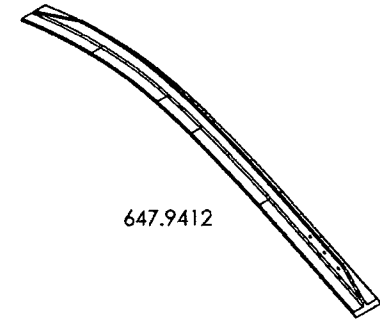
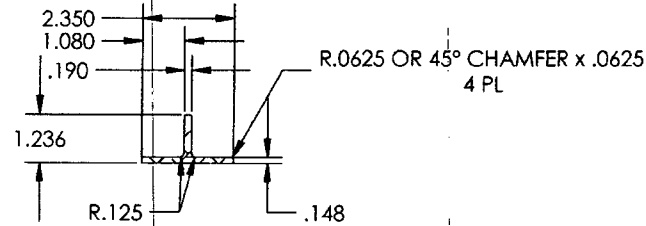
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OFFICIAL DATE (LAC-01-12) 06-09-10 DESIGNED BY S. JOHNSON DRAWING APPROVAL P. BROWN CHECKED BY P. BROWN CONTRACT NO.		<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES SURFACES ARE 2 PLACE DECIMALS ±.02 3 PLACE DECIMALS ±.010 ANGLES ±.5°		<b>DEFLECTORS</b>	
SIZE 8	CAGE CODE 07M26	DWG. NO. <b>647.9400</b>	REV. 8
SCALE NONE		SHEET 5 OF 9	



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<small>           ORIGINAL DATE            (DD-MMM-YY)    DWG. NO.            DRAWN BY    CHECKED BY            R. TORIANO    P. BRAVO            DRAWING APPROVAL            P. BRAVO            DWG. NO.            CONTROL NO.         </small>		<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
<small>           UNLESS OTHERWISE SPECIFIED            DIMENSIONS ARE IN INCHES            TOLERANCES ARE:            1. FRACTIONS .001            2. DECIMALS .010            3. PLACE DECIMALS .001            4. ANGLES .5°         </small>		SIZE CAGE CODE    DWG. NO. B    07M26    647.9400	REV. B
SCALE: NONE		SHEET 6 OF 9	

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

647.9413

20.2°

Ø.192 THRU  
3 PL

1.236  
.751  
.733  
0

2.813  
4.313  
5.813

H  
H

R.485

26.341  
26.961

2.350  
.190  
1.080  
R.0625 OR 45° CHAMFER x .0625  
4 PL  
1.236  
R.125  
.148

SECTION H-H

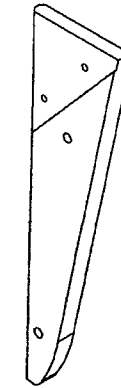
<small>         ORIGINAL DATE          05-04-1980          DRAWN BY          T. J. JOHNSON          CHECKED BY          J. BRAVO          DRAWING APPROVAL          J. BRAVO          PROJECT NO.          647.9400       </small>		<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
<small>         UNLESS OTHERWISE SPECIFIED          DIMENSIONS ARE IN INCHES          DECIMALS ARE TO 3 PLACES          3 PLACES DECIMALS = .003          ANGLES ± .5°       </small>		DWG. NO. <b>647.9400</b>	REV. 8
SHEET B		SCALE NONE	SHEET 7 OF 9

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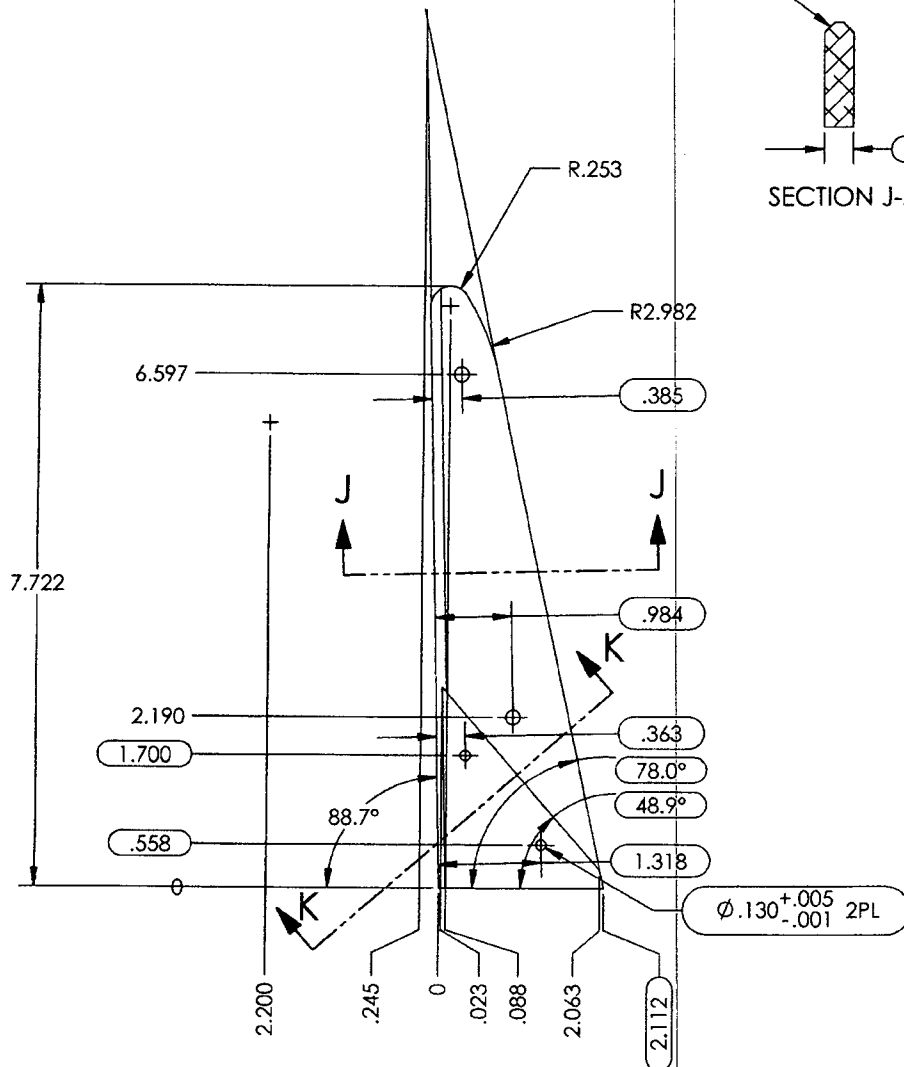
13 x 45°  
2 PL

SECTION J-J  
.380

SECTION K-K  
(.280)  
.050  
2 PL



647.9414



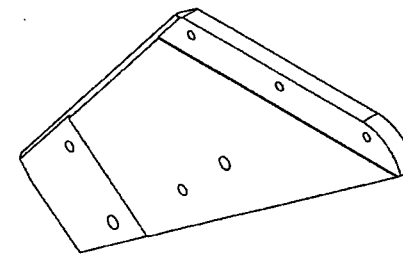
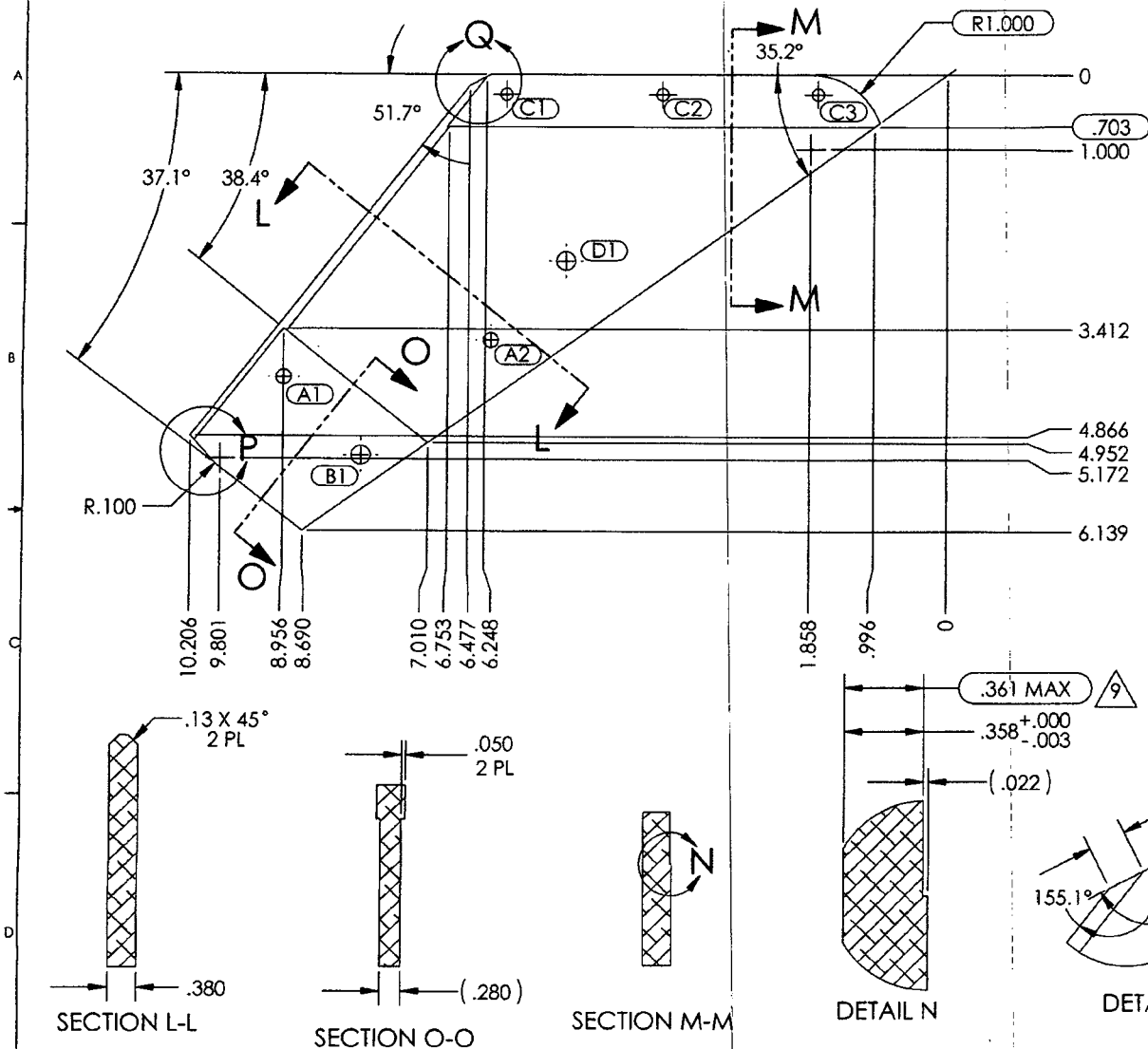
ORIGINAL DATE 06-07-10  
DRAWN BY J. HICKER  
& FORNARD J. SALVO  
DRAWING APPROVAL  
P. BRAVO  
DATE 10-20-10  
CONTRACT NO.

APICAL INDUSTRIES  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760)724-5300

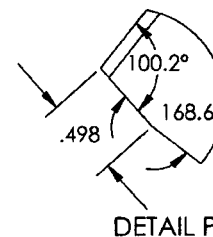
DEFLECTORS

SIZE	CAGE CODE	DPG. NO.	REV.
B	07M15	647.9400	3
SCALE NONE			SHEET 8 OF 9

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647.9415



TAG	X LOC	Y LOC	SIZE
A1	-8.949	-4.066	Ø.201
A2	-6.172	-3.562	Ø.201
B1	-7.903	-5.121	Ø.253
C1	-5.978	-.267	Ø.165
C2	-3.863	-.267	Ø.165
C3	-1.758	-.267	Ø.165
D1	-5.159	-2.500	Ø.250

ORIGINAL DATE: 06-07-10 DRAWN BY: J. P. BISHOP CHECKED BY: J. P. BISHOP DRAWING APPROVAL: J. P. BISHOP REVISION: 10-07-10 CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS .001 ANGLES ± 5°		REV. B	REV. B
CAGE CODE: 07M26		DWG. NO. 647.9400	SHEET 9 OF 9
SCALE: NONE			





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO23813

Purchase Order Date 4/15/2014

PO Print Date 4/25/2014

Page Number 4 of 6

**Order From :**

VC-ATG001

**Ship To :** DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.  
731 INDUSTRIELLE ROAD  
ROCKLAND, ON K4K 1T2  
CANADA

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 613-446-4544

**Ship To Contact**

**Ship To Phone**

**Ship Via:** VENDOR'S TRUCK

**Ship Acct:**

**Buyer**

**Customer POID**

**Customer Tax #** 10127-2607

**Terms** Net 30

**Currency** CAD

**FOB** FCA - (Free Carrier)

**Line Total:** \$36.30

10	109496	646.9812 LOWER CUTTER DEFLECTOR	5/7/2014	4.00	\$18.15	✓	\$72.60
----	--------	---------------------------------	----------	------	---------	---	---------

Yes

5/7/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

**Line Total:** \$72.60

11	109618	647.9410 LOWER DEFLECTOR	5/7/2014	4.00	\$10.70	✓	\$42.80
----	--------	--------------------------	----------	------	---------	---	---------

Yes

5/7/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

**Line Total:** \$42.80

12	112221	647.9411 UPPER DEFLECTOR	5/7/2014	8.00	\$24.50	✓	\$196.00
----	--------	--------------------------	----------	------	---------	---	----------

Yes

5/7/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

**Note:**

4/25/2014



A.T.G. Industries Inc.  
 731, rue Industrielle Rd.  
 PLATING DEPARTMENT  
 Rockland, On K4K 1T2  
 Canada  
 Ph: (613) 446-4544  
 Fax: (613) 446-4556

## Pack List

Number: 63000

Date: 24-Apr-14

To

DART AEROSPACE LTD  
 1270 ABERDEEN ST.  
 HAWKESBURY, ON K6A 1K7  
 Canada

Ship To

DART AEROSPACE LTD  
 1270 ABERDEEN ST.  
 HAWKESBURY, ON K6A 1K7  
 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity		Description	
1	Part: ASST	Rev:	
lot	20 PCS 646.3313 (13.10) 11 PCS 646.3810 (6.55) <i>675</i> 10 PCS 646.3812 (6.10) 16 PCS 646.3813 (6.10) 12 PCS 646.9811 (32.60) 10 PCS 646.9812 (18.15) 4 PCS 647.9410 (10.70) 8 PCS 647.9411 (24.50)  HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2  PRIME MIL-P-23377J TYPE I CLASS N  3 PCS D2224 (2.00) ✓ RED ANODIZE MIL-A-8625 TYPE II CLASS 2  PRICE IS PER PIECE Job: 20140236 PO: 23813 Line:		
Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: <i>24/4/14</i> CERTIFIED SIGNATURE: <i>[Signature]</i> RECEIVER SIGNATURE: _____			